

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009529**Date Inspected:** 08-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Chuan Ging , Tu Jun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower/OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY #10

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 4A located on PCMK NSD1-SPSA3-56. Welder is identified as 040533 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-F.

FCAW welding process of weld joint 42 located on PCMK SD1-A712A/F. Welder is identified as 053116 ZPMC QC is identified as Tu Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

FCAW welding process of weld joint 43 located on PCMK SD1-A712A/F. Welder is identified as 057180 ZPMC QC is identified as Tu Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

SOUTH TOWER LIFT #4

FCAW welding process of weld joint 146 located on PCMK SSTL4-1I/L. Welder is identified as 052075 ZPMC QC is identified as Wang Chuan Ging. The welding variables recorded by QC appeared to comply with the

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WPS-B-T-4332-TC-P5-F.

FCAW welding process of weld joint 151 located on PCMK SSTL4-1K/L. Welder is identified as 053869 ZPMC QC is identified as Wang Chuan Ging. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

FCAW welding process of weld joint 149 located on PCMK SSTL4-1C/L. Welder is identified as 057266 ZPMC QC is identified as Wang Chuan Ging. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

FCAW welding process of weld joint 143 located on PCMK SSTL4-1G/L. Welder is identified as 054069 ZPMC QC is identified as Wang Chuan Ging. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

BAY #11

This QA Inspector randomly observed the following work in progress.

SMAW welding process of weld joint 10B located on PCMK SSD1-A6002-18. Welder is identified as 041271 ZPMC QC is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-2G (2F) - FCM-Repair-1. The Critical weld repair report identified as T-CWR270 and ZPMC ultrasonic inspection report identified as T787-UT-2274.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT-5CW

This Quality Assurance (QA) Inspector observed ZPMC personnel performing match drilling on deck panel 'U' rib at PP35 in OBG segment 5CW.

OBG SEGMENT-5AW

This Quality Assurance (QA) Inspector observed ABF NDT Inspector performing magnetic particle inspection on the hold back weld of 'T' stiffener to side panel and bottom panel at field splice location of OBG segment 4BW and 5AW.

INCIDENT

BAY #11

EAST TOWER LIFT #4

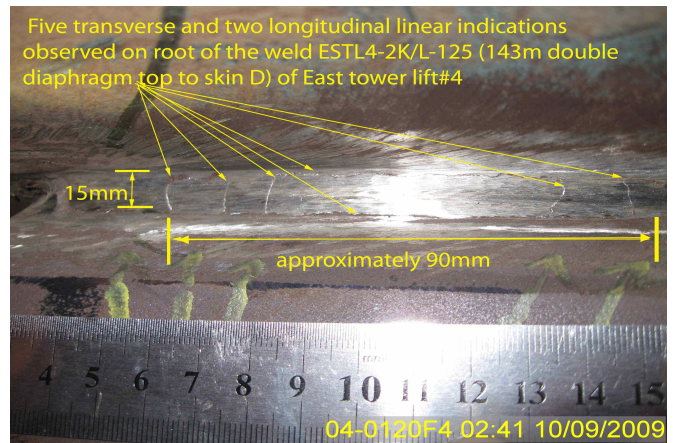
During random visual inspection of East tower lift #4, this Caltrans Quality Assurance (QA) Inspector observed five transverse and two longitudinal linear indications in the root of the 143m double diaphragm top to the skin 'D' weld ESTL4-2K/L-125. The linear indications were shown to ZPMC and ABF QC Inspectors. See the photos

WELDING INSPECTION REPORT

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below for additional information.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Dawson,Paul

QA Reviewer